

# Work Order ID 53032

October 22, 2009 10:06:13 AM



Page 1

Item ID: D3897-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Angle

Start Date: 21/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PL

Date: 09-10-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3897

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3897

Dwg Rev: B

Prog Rev: B

\*\*\*grain direction per dwg\*\*\*

2-Deburr if necessary

B 9-10-30

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 9-10-30

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Item ID:	D3897-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Angle					
Start Date:	21/10/2009	Start Qty:	6.00	Cust Item ID:		
Required Date:	30/10/2009	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00	SB 02/10/30			(15)	7		
130  Small Fab Small Fab	Memo 1- Deburr if necessary	0.00 0.00							
140  Brake NC Brake NC	Memo 1- Bend as per dwg	0.00 0.00	SB 09/11/05			(8)	0		

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	⇒ Sorlulos			(X8)	φ		
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	J 09/11/06			(X8)	φ		
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	MND 09/11/06			X8			

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Item ID: D3897-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Angle

Start Date: 21/10/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: B30

0.00



Packaging

Memo

0.00

Packaging

9/11/9



190

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/09

Pl 09/11-9

# Picklist Print

October 22, 2009 10:06:17 AM

Page 1

Work Order ID: 53032



Parent Item: D3897-1RevB



Parent Item Name: Angle

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased		No			sf	43.0054	1.5000			
6061-T6 .050 Sheet												



18 9-10-30

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	43.0053	
110791	34.5715	
112567	6.4338	
17349	2	

112567

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53032
<b>Description:</b> ANGLE		<b>Part Number:</b> D3897-1
<b>Inspection Dwg:</b> D3897- Rev: B		Page 1 of 1

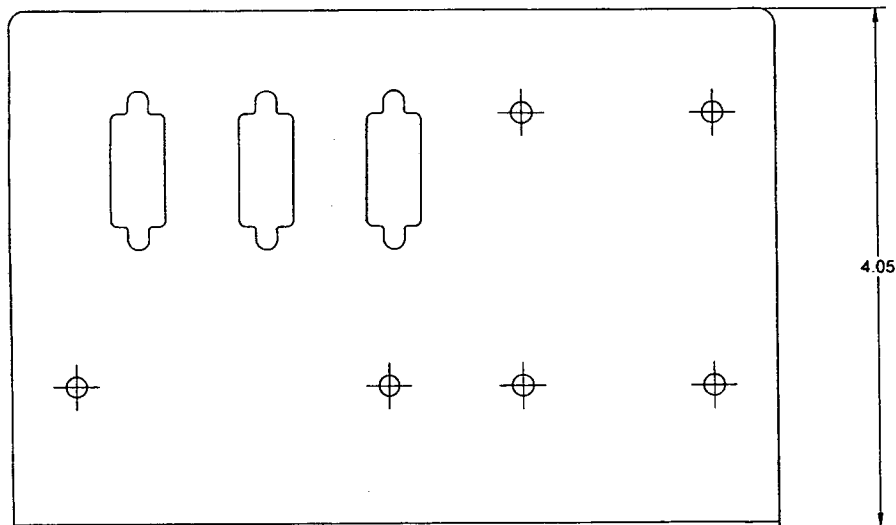
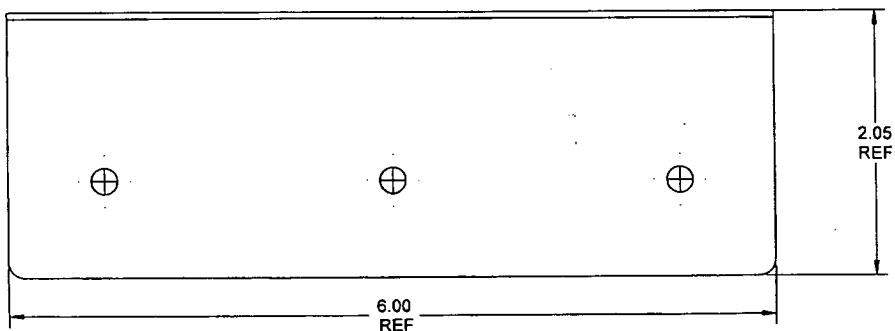
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .159	+ .005 - .001	.162	✓			
Ø .204	+ .005 - .001	.206	✓			
.425	± .010	.427	✓			
.880	± .010	.883	✓			
1.239	± .010	1.239	✓			
.50	± .030	.503	✓			
1.500	± .010	1.497	✓			
3.00	± .030	3.00	✓			
4.00	± .030	4.001	✓			
5.00	± .030	5.002	✓			
6.00	± .030	6.006	✓			
.81	± .030	.812	✓			
2.94	± .030	2.941	✓			
5.10	± .030	5.107	✓			
5.85	± .030	5.858	✓			
.75	± .030	.751	✓			
3.00	± .030	3.003	✓			
5.25	± .030	5.255	✓			
.050	± .010	.048	✓			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b> N/A
<b>Date:</b> 9-10-30	<b>Date:</b> 02/10/30	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

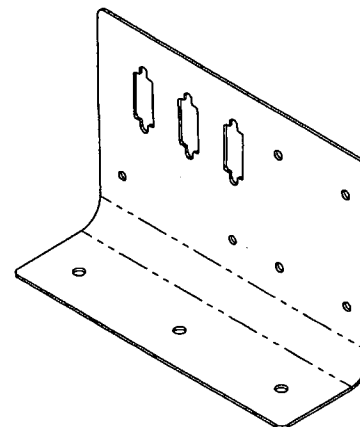


6

**D3897-1 ANGLE**  
MADE FROM D3897-1F

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 53032

*RE 09-10-27*

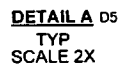


B  
R0.44

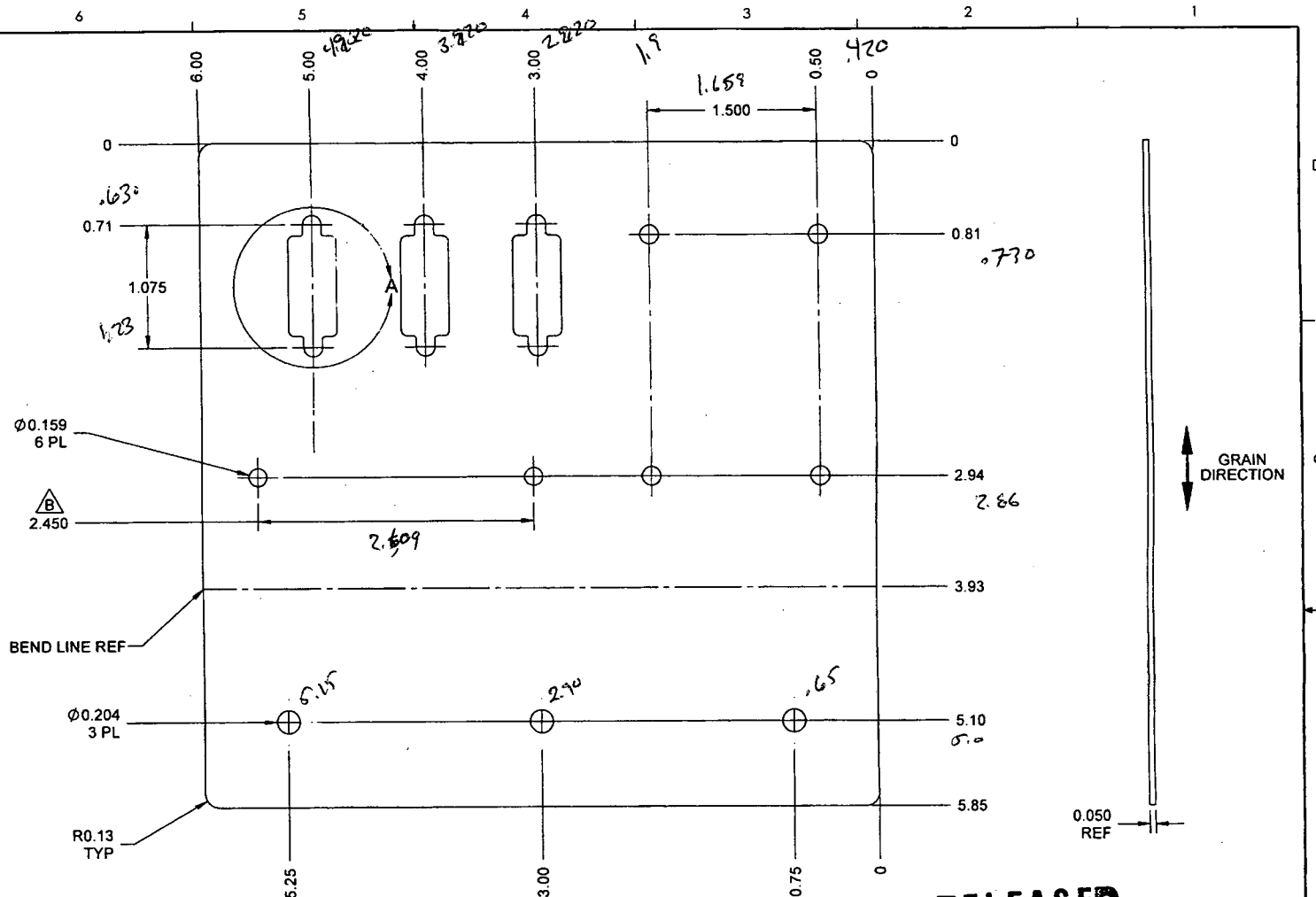
**RELEASED**  
2009-08-28  
*WD*

NOTES:  
MATERIAL: MADE FROM D3897-1F  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: IDENTIFY WITH DART P/N "D3897-1" AND B/N USING FINE POINT PERMANENT INK MARKER  
WEIGHT: 0.16 lbs

B	CHANGED BEND RADIUS FROM 0.50 TO 0.44 (ZN B3-1) AND HOLE DISTANCE FROM 2.06 TO 2.45 (ZN C8-2).	KB	09.06.09
A	NEW ISSUE	<i>KB</i>	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>KB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>KB</i>		
CHECKED	<i>KB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>KB</i>	D3897	SHEET 1 OF 2
APPROVED	<i>KB</i>	TITLE	SCALE
DE APPR.	<i>KB</i>	ANGLE	NTS
DATE	09.06.09	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



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WITHOUT NOTICE  
WORK ORDER  
NO. 53030



RELEASE  
2009-08-28

**D3897-1F ANGLE FLAT PATTERN**

(REF DART SPEC M0001100.000)  
 ) FINISH: N/A  
 ) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 ) UNITS: INCHES UNLESS OTHERWISE NOTED  
 ) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 ) IDENTIFICATION: N/A  
 ) WEIGHT: 0.16 lbs

DESIGN	BE	<b>DART AEROSPACE LTD</b>	
DRAWN	KB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. 0
MFG. APPR.	E	D3897	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	11	ANGLE	NTS
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